

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004052**Date Inspected:** 05-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA	CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use: Yes No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed: Yes No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up: Yes No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS: Yes No N/A
				Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Heavy bay #3

The QA Inspector observed ZPMC magnetic particle QC Inspector Mr. Wang Wei performing magnetic particle inspection (MT) of deck panel DP572-001 in the areas that had been repaired following initial visual inspections by QC, ABF and QA Inspectors. Mr. Wei identified a transverse indication in weld 8 and the weld was ground to a depth of approximately 4 mm depth until the MT indication was removed. ZPMC QC Inspector Mr. Bo indicated this area will be weld repaired.

ZPMC QC Inspector Mr. Sun Bo informed the QA Inspector that he is not aware of any deck panels that will be ready for final visual inspections this shift.

Heavy bay 2

The QA Inspector observed various welders and grinders working on tower skin plates A, B, C and D.

Bay 1

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The QA Inspector observed ZPMC personnel are performing heat straightening of deck plate DP615-001 as directed by HSR1(B)2235 in the area where two base plates have been welded together. ZPMC has a 10 ton weight adjacent to the weld that is being heated and one QC Inspector is measuring and recording the base material temperatures at regular intervals. Items observed appear to comply with project specifications. See the photograph below for additional information.

The QA Inspector observed ZPMC has not performed tack welding of any closed ribs on any baseplates.

OBG Assembly Bay #2

The QA Inspector performed ultrasonic inspection of completed welds on deck panel DP071-001 to locate potentially cracked tack weld locations. QA observed 3 of 128 welds that were inspected requires additional evaluations with the phased array ultrasonic technique to determine if the welds contain cracks.



Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
